Work Order ID 54586

Page 1

December 14, 2009 1:11:00 PM

Required Date: 21/12/2009

Item ID:

D205-634-041

Accept

Setup Start

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

14/12/2009

Start Qty: 1.00 Req'd Qty: 1.60

Cust Item ID:

Customer:

Reference:

Approvals:

Date:

Run

Start

Stop

QC:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

Operation Description Set Up/ **Run Hours**

Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Number Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

W 0912-14

110

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

49/12/17

W/O:			WO	RK ORDER CHANGES	<u> </u>			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approvat- Chief Eng / Prod Mgr	Approva QC Inspector
Part No		PAR #:						
	Reso	olution:	Disposition	:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	R)		
		Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspecto
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Work Order ID 54586



Page 2

December 14, 2009 1:11:01 PM

Required Date: 21/12/2009

Item ID:

D205-634-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

14/12/2009

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date: **Tooling:** Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

Skidtubes Skidtubes

Description

Operation

Set Up/ Run Hours

0.00

0.00

Number

Rev.

Code

Accept Qty Qty

Reject Reject Number

Stamp

Memo

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

BE 10-01-04

Memo

W/O:			WORK ORDER	CHANGES					
DATE	STEP		PROCEDURE CHANGE	·	Ву	Date	Qty	Approvat - Chief Eng / Prod Mgr	Approval QC Inspector
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				•					
Part No):	PAR #:	Fault Category:	NCI	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition:	QA	N/C C	losed:		Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector			
50°04											

Page 3

December 14, 2009 1:11:01 PM

Item ID:

D205-634-041

Accept



Setup Start



Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

14/12/2009

Start Qty: 1.00

Required Date: 21/12/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Start Run

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

140

Skidtubes Skidtubes

Operation Description Set Up/ Run Hours Number

Draw Plan Rev. Code

Accept Qty

Reject Qty

Stamp Number

Memo

0.00

0.00

1-Weld step D2576 as per Dwg. D2580 and QSL004 A/RDDC Aluminum Rod A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

A/R□□□ Aluminum Rod

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill, A/RCDD Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Towring using DT8091, open to .640"and Deburr

a.A 2.10.01.09

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W/O:			WC	ORK ORDER CHANG	ES								
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approvat Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No D C	QA:	Date: _					
	Resolution: Dispe		Dispositio	n:	_ QA: N/C	Closed: _		Date: _					
NCR:		\	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC Section A	Initial Action Descri		on B Sig	1&∤ _{Sec}	ication ction C	Approval Chief Eng	Approval QC Inspector				
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Work Order ID 54586 December 14, 2009 1:11:01 PM



Page 4

Requir d Date: 21/12/2009

Item ID:

D205-634-041

Accept



Setup Start

(<u>1887</u>)



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

14/12/2009

Start Oty: 1.00 Reg'd Qty: 1.00

Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Stop

Sequence ID/ Work Center ID

150

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Draw Number Rev.

BR 1001-11 D

Plan Accept Qty Code

Reject Qty

Reject Insp. Number

Stamp

160

OC

Quality Control

QC5- Inspect part completeness to step on W/O

170

HandFinish

Hand Finishing

Pressure Wash per OSI005 4.3

Memo

Memo

0.00

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES				,
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #: Fault Category:	NCR: Yes	No DO	۸٠	Date:	1

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B			Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector				
						:						
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Work Order ID 54586

December 14, 2009 1:11:01 PM

Item ID:

D205-634-041

Revision ID:

Item Name:

Regiacement Skidtube

Start Date: Required Date: 2 1/12/2009

Start Oty: 1.00 14//12/2009

Accept

Setup Start



Run

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: ____

Draw

Rev.

Reject

Qty



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Reject

Number

Start

Stamp

Sequence ID/ Work Center ID

180

Powdercoat

Powder Coating

Operation Description

Reg'd Qty: 1.00

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

Memo

START TIME: OVEN TEMPERATURE

FINISH TIME:

10/01/11

Number

Draw

Plan

Code

Accept

Qty

190

QC **Quality Control**

QC3- Inspect Part Finish

0.00

0.00

BR 10-01-13 -D-B.

Memo

Dart Aerospace

Dart Ae	rospace	e Ltd								
W/O:				WORK ORDER (CHANGES					1
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):		PAR #:	Fault Category:	NCR:	Yes	No DQ	A :	Date: _	
	R	esolution:		Disposition:	QA: 1	WC C	losed:		Date: _	
NCR:				WORK ORDER NON-CON	FORMANCE	(NC	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B		Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			

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December 14, 2009 1:11:01 PM

Item ID:

D205-634-041

Revision ID:

Item Name:

Replacement Skidtube

Start Date: 14/12/2009 Required Date: 21/12/2539

Start Qty: 1.00 Req'd Qty: 1.00



Date:

Accept



Setup Start



Stop

Reference:

Approvals:

Process Plan:

QC:

__ Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Run

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** Draw Number

Cust Item ID:

Customer:

Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

200

HandFinish Hand Finishing

Memo

0.00

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R DDU Sikaflex-291 //2845 DDU

Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive A/R 🗆 🖂 Sikaflex-291

Sikaflex expire date: _/0/09

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

BP 10-01-13 D

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval. Chief Eng / Prod Mgr	Approval QC Inspector	

Part No:	PAR #:	Fault Category: _	 NCR: Yes	No	DQA:	Date: _	
Resolution:		Disposition:	QA: N/C CI	osed	:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC Corrective Action Section B V				Verification	Approval	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspecto				

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December 14, 2009 1:11:01 PM

Required Date: 21/12/2009

Item ID:

D205-634-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

14/12/2009

Start Oty: 1.00

Req'd Qty: 1.00

Cyst Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID

210

Quality Control

Operation Description

Packaging

OC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

Number

Draw Rev.

Plan Accept Code **Qty**

Reject Qty

Reject Insp.

Number Stamp

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per OSI 024

220

Packaging Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location:

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

0.00

0.00

- 10/01/18/0 MF 10-1-15.

230

Quality Control

W/O:			WO	RK ORDER CHANG	ES				,
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR)								
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Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Yes	No DQ	A:	_ Date:	
	R	esolution:	Disposition	:	_ QA: N/C C	osed:		Date:	·
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	₹)			
DATE	STEP	Description of NC						Approval	Approval
		. Section A					ion C	Chief Eng	QC Inspector
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December 14, 2009	1·11·05 PM											Page 1
Work Order ID: 545 Parent Item: D2		ıbe							tart Date: 14/1: Start Qty: 1.00	2/2009	Required Date Required Qty	
Component Item ID/ Item Name	Replacement Item ID	√fg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit :: Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status 1.
D2580-1 205 Skidtube bent detail		Manufactured	No			110	Each	7.0000	1.0000			
205 Skiddade dein detail				Wareho		<u>Loc</u>	<u>Qty</u>	Loc Code				
					<u>ation</u>							
				Main W	arehouse			~ (
		R5.	41/				4	1/1	ーン ク=	12	-17	
		$\mathcal{D}\mathcal{D}$	10	4/	54120 54279		2 2		(1 -	10	- / /	
				Main W	arehouse		2		-		_	
				ST	archouse		3					
				0.	53540		1				-	
					54121		2				_	
D2576-3		Manufactured	No			140	Each	156.0000	1.0000			
										· · · · · · · · · · · · · · · · · · ·		••
Step (maching detail)				Wareho	ouse	Loc	Oty	Loc Code				
					ation		-					
				Main W	arehouse							
				ST			156		1/ -		- 0	laches
					43504		8		X _		- BE 10	
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W/O:			WC	ORK ORDER CHANGI	ES					4
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
28										
						<u> </u>	,			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQ/	4 :	Date:	
	R	esolution:					ed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approvai
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

December 14, 2009 1:11:05 PM

Work Order ID: 54586

Parent Item:

Comments:

D205-634-041

Parent Item Name: Replacement Skidtube

Manufactured



Start Date: 14/12/2009

Required Date: 21/12/2009

Page 2

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Replac Item Name Item II	•	Last Route Location Seq ID	Unit of Qt #3 Measure Hand	9	Qty Issued	Date Issued	Status
D2579	Manufactured No	140	Each 363.00	20.0000	· · - - - ·		

Crossbolt Spacer

Warehouse	Loc	: Oty	Loc Code				
Location							
Main Warehouse							
LG		241					
51525		4					,
53780		130					1/./
54543		107		X.	20	BE	10/01/04
Main Warehouse			2				
ST		122					
43988		4					
46434		4					
46956		2					
47797		9					
48272		2					
51314		71					
51315		30					
	200	Each	55.0000	1.0000			

D2855 Cap

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
FP6	55	
50513	1	
50770	3	
50770 51539	51	

1 /sl 10-01-13.

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W/O:			WORK ORDER	CHANGES				,
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR: Ye	es No DQ	A:	Date: _	
	Resolu	tion:	Disposition:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDER NON-CON	IFORMANCE (N	CR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC Corrective Action Section B				Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
						;						

Picklist Print

December 14, 2009 1:11:05 PM

Work Order ID: 54586

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:



Start Date: 14/12/2009

Required Date: 21/12/2009

Page 3

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Birst, Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Reseaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A	<u> </u>	Purchased	No ·		200	Each	2,027.000				

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2027	
100188	188	
100188 105057	1835	
15205	4	

AN960ID10L

Purchased

No

200

Each

5,427.000 2.0000



711.7003.2.102	

Washer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5427	
101291	16	
104885	153	
105793	236	
109632	268	
110985	4754	

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2 bf 10-01-13.

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W/O:			WC	RK ORDER CHANG	ES					· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				1						,
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQ	A :	Date: _	
	R	esolution:	Disposition	ı:	_ QA: N/0	Clos	sed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	ANCE (N	CR)				
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DATE	STEP Description of NC Section A		Initial Chief Eng				Section C		Chief Eng	QC Inspector
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Picklist Print

December 14, 2009 1:11:05 PM

Work Order ID: 54586

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:



Last

Start Date: 14/12/2009

Required Date: 21/12/2009

Start Qty: 1.00

Required Qty: 1.00

Criponent	Item	ID/
ltern Name		

Replacement Mfg/ Purch Item ID

Bin Primary Item Location

No

No

Location

Route Seq ID Unit of Measure Hand

Qty on

Remaining ... Qty Qty To Pick Issued

Date Issued

Status

Page 4

ALS7-1032-130

Purchased

Purchased

200

Each

2,080.000 50.0000



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Loc Qty Loc Code Warehouse Location Main Warehouse ST 2080 105855 16 52 108606 111529 688 111779 313 112772 11 1000 113238 1,661.000 50.0000 200 Each

AN3C4A

BOLT

Warehouse Location	Loc Oty	Loc Code
Main Warehouse		
ST	1661	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	74	
113226	990	
113359	66	
113422	500	

30 Bf 15-01-13

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W/O:			W	ORK ORDER CHANG	ES				
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	1 4 :	Date:	
				QA: N/C Closed: Date:					
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NCR	R)			
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DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector

Picklist Print

December 14, 2009 1:11:05 PM

Work Order ID: 54586

Parent Item:

Comments:

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 14/12/2009

Required Date: 21/12/2009

Start Qty: 1.00

Required Qty: 1.00

Compone , lter	n ID/
Item Name	

Item ID

Replacement Mfg/ Purch

Bin Primary Item Location

#_ast Location Route Seq ID

Unit of Measure Hand

Qty on Remaining Oty 2 Qty To Pick Issued

Date Issued

50. Bh 10-01-13.

Status

Page 5

AN960C10L

Purchased

200

Each

500.0000 50.0000

washer

NAS 149 CO 332 R

<u>Lo</u>	oc Qty	Loc Code		
<i>38</i>	100			
	100			
	400			
	228			
	160			
	12			
200	Each	100.0000	1.0	
	- 38	100 400 228 160 12	38 100 100 400 228 160 12	

D3566-13

Manufactured

0000

Gasket

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
FP /	98		
51606	15		1 Dt 10-01-B.
53461	83		
Main Warehouse			
ST	2		-
45717	1		
50265	1		

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W/O:			WO	RK ORDER CHANG	ES				•	
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:		
•			Disposition: QA							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC Section A	Corrective Action S Initial Action Description		ction B V		Verification Appro Section C Chief E			
		Section A	Chief Eng	Chief Eng	Dat	e Sect	ION C	Chief Eng	QC Inspector	

Picklist Print

December 14, 2009 1:11:05 PM

Work Order ID: 54586

Parent Item:

Comments:

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 14/12/2009

Oty

Required Date: 21/12/2009

Start Oty: 1.00

Required Qty: 1.00

Component Item ID & Item Name

Replacement Mfg/ Item ID Purch

Bin Primary Last Item Location Location

Route Seq ID Unit of

Oty on Measure Hand

Remaining Qty To Pick Issued èate Issued

1 bl 10-01-13.

Status

Page 6

D3566-5

Manufactured

200

Each

26.0000 1.0000

Gasket

Warehouse	Loc	c Qty	Loc Code	
Location				
Main Warehouse				
FP)		22		
53804		22		
Main Warehouse				
ST		4		
36113		1		
46186		1		
47318		1		
51260		1		
	200	Each	22.0000	2.0000

D3566-1

Manufactured

Gasket

Warehouse	Loc Qty	Loc Code	
<u>Location</u>			0 0
Main Warehouse			2 /// 10-01-1
fp 54480	17		
52512	3		
53790	14		
Main Warehouse			
ST	5		
46349	1		
51218	l		
51259	3		

W/O:				WORK ORDER CHANGES						
DATE	STEP		PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1		
Part No	:		PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date:	
	F	Resolution:		Disposition:	OA· N	/C C	losed:		Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
***************************************		Description of NC		Corrective Action Section B			Approval	Approval
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Date		Verification Section C	Chief Eng	Approval QC inspector	
								}

December 14, 2009 1:11:06 PM

Work Order ID: 54586

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 14/12/2009

Required Date: 21/12/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name

Researcement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location Rou* Seq ID

Unit of

Qty on Measure Hand

Remaining Qty To Pick Issued

Qty

Date 12 Status Issued

D3564-11

Manufactured

Manufactured

Each

25.0000 1.0000

Wearshoe

Warehouse	Loc	: Qty	Loc Code		
Location					
Main Warehouse					2
FP19		23			
52125		14			TBL 10-01-13.
53808		9			-
Main Warehouse					
ST		2			
45823		1			
50112		1			
	200	Each	40.0000	1.0000	

D3564-13

Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP17 /	28	
51611	28	
Main Warehouse		
ST	12	

2

10

	//		
/	DA	10-01-13.	

45409

46495

D	art	: A	erc	sp	ac	e	Ltd
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W/O:		WORK ORDER CHAI	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
' -										

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
ı	Resolution:		Disposition:	QA: N/C Closed	l:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B								
DATE	STEP	Section A	InitialAction DescriptionSign &Chief EngChief EngDate		Verification Section C	Approval Chief Eng	Approval QC inspector				
		4									
·											

Picklist Print

Page 8

December 14, 2009 1:11:06 PM

Work Order ID: 54586

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 14/12/2009

Required Date: 21/12/2009

Start Oty: 1.00

Required Qty: 1.00

Date

Issued

Component Item ID/ Item Name

Replacemen . Mfg/ Purch Item ID

Bin Primary Item Location Last Location

Route Seq ID U≉tof Qty on Measure Hand

Remaining Qty Qty To Pick Issued

Status

D3564-9

Comments:

Manufactured

No

200

Each

22,0000

1.0000

Wearshoe

Warehouse	<u>Lo</u>	c Qty	Loc Code	
<u>Location</u>				
Main Warehouse				
FP19		20		
53806		20		
Main Warehouse				
ST		2		
44659		1		
45825		1		
	200	Each	25.0000	1.0000

1 \$\$10-01-13.

D3564-5

Manufactured

Wearshoe

Warehouse	Loc Oty	Loc Code
Location		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	21	
51925 /	i	
51925 53805	20	
Main Warehouse		
ST	2	
45824	1	
47433	1	

DD /2 21 12			
	12 //	10-11-	10

Dart Aerosp	pace Ltd
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Dart Aeı	rospace	Ltd							
W/O:			WO	RK ORDER CHANGE	S				*
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•	:					•			
Part No	:	PAR #:	Fault Categ	gory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition);	QA: N/C C	losed:		Date: _	
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NC	3)			
		Description of NC		Corrective Action Section	ion B		fication Appro		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Sect	tion C	Chief Eng	QC Inspector

Picklist Print

December 14, 2009 1:11:06 PM

Work Order ID: 54586

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:



Start Date: 14/12/2009

Required Date: 21/12/2009

Page 9

Start Qty: 1.00

Required Qty: 1.00

16 th 10-01-13.

Component Item ID/ Item Name	Replacement Item ID	Mfg# Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	⊮Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3		Manufactured	No			200	Each	498.0000	16.0000			



O-Ring, 205 Skidtube

Warehouse	Lo	c Qty	Loc Code	
Location				
Main Warehouse				
FP		27		
51613		27		
Main Warehouse				
ST /		471		
52562		471		
	200	Each	281.0000	16.000

D2594-1

Manufactured

Plug, 205 Skidtube

	51613		27		
Main Wa	rehouse				
ST	/		471		
	52562		471		
		200	Each	281.0000	16.

Warehouse	Loc Oty	Loc Code	
<u>Location</u>			
Main Warehouse			1. 1.1
FP 5464 B	121		16 Bh 10-01-13
54008	121		
Main Warehouse			
ST	160		
42221	16		
42807	92		
43884	3		
46435	2		
51527	9		
51757	38		

W/O:

	1			I	_ · · · · · · ·	A	<u> </u>
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·					
					!		
Part No	•	PAR #: Pault Category: NC	R: Yes	s No DQ	٨:	Date:	

WORK ORDER CHANGES

Resolution:		esolution:	Disposit	ion:	QA: N/C Clos	sed:	Date: _				
NCR:		1	WORK ORDER NON-CONFORMANCE (NCR)								
DATE		Description of NC		Corrective Action Section I	3	Verification	Approval	Approval			
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector			
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					}						
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DESIG	*##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED.	APPROVED	DRAWING NO. REV. D
		#	D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	2.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
С		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183



QTY -041	QTY -045	Part Number	Description
Х		D2580-041	SKIDTUBE ASSEMBLY
	Х	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COP RETURNT **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMEN IMENT WITHOUT NOT CE

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-
- 6) WELDING TO BE DONE PER DART QSI 004.
- FINISH:

SEE NOTES ON

PAGE 2 FOR D2580-041 AND

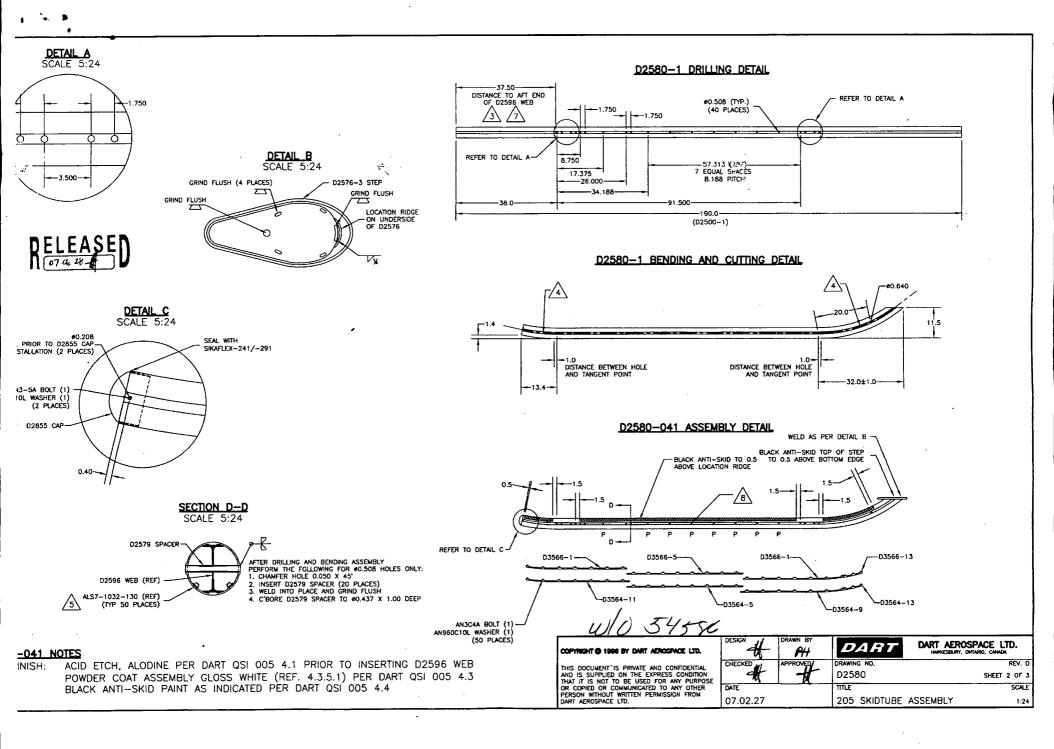
PAGE 3 FOR D2580-045

INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:			٧	VORK ORDER CHANGE	S	<u></u>			
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	:								
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _		
	R	Resolution: QA: N/C Closed:				sed:	ed: Date:		
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification	Approval	Approval	
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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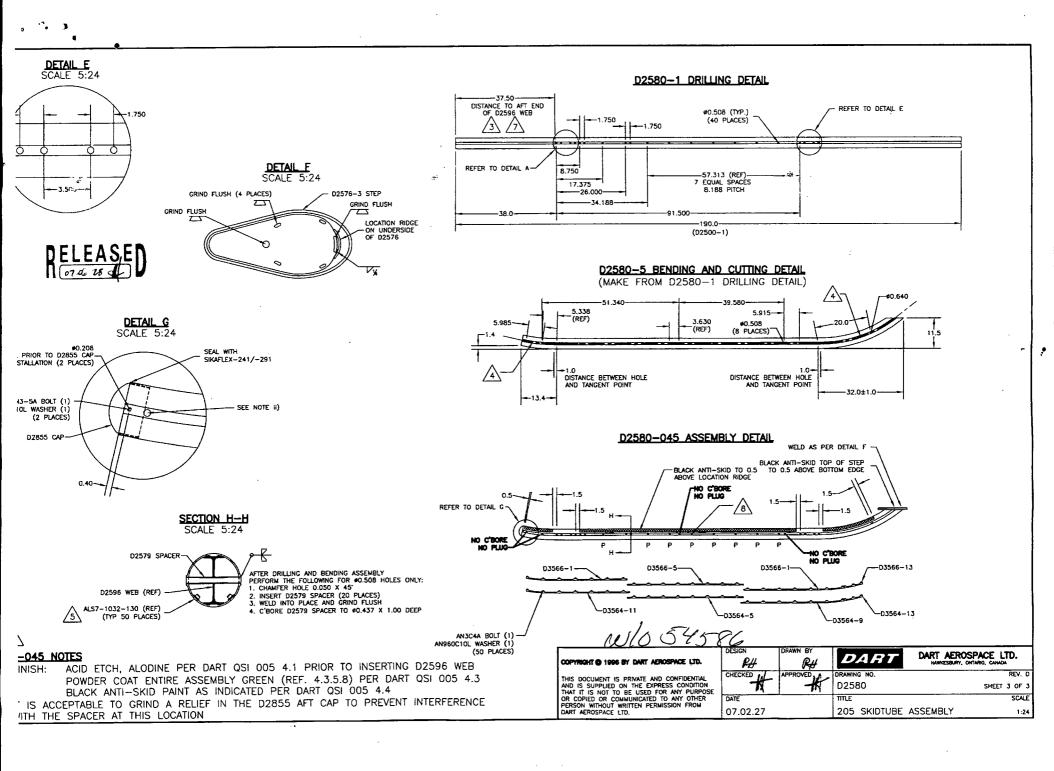


Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	· · · · · · · · · · · · · · · · · · ·	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Approval	Annessal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Approval Section C Chief Eng		Approval QC Inspecto			
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W/O: WORK ORDER CHANGES				,	•				
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault Category:	N	ICR: Yes	No DQ	 A:	Date:	

Resolution:		Disposition	n:	QA: N/C Clos	sed:	Date: _		
NCR:			WORK ORDI	ER NON-CONFORMAN	NCE (NCR)			
		Description of NC		Corrective Action Section	В	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Borday Elliett
Job number: 54202]
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig Mig
Base materiel: Aluminium
Current: AC[/ DC[]

TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[/] fail[] pass[/] fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier (o)	_Date of Test Coupon _C @
Welder Boxclay Educat	Date of Test Coupon <u>C9-12-17</u>
//	

The above named individual is qualified in accordance with AWS D17.1.2001 to weld